

Work Order ID 166089

Monday, September 11, 2017 9:18:51 AM

166089

Page 1

Item ID: D4021-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Plate

Start Date: 9/11/2017 Start Qty: 36.00 ***36*** Cust Item ID:
 Required Date: 9/12/2017 Req'd Qty: 36.00 ***36*** Customer:

Reference: **DAS** **SEP 11 2017**

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 11 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4021	B

100		0.00							DAS 40 9-89
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100

Waterjet
FLOW CNC Waterjet

Memo
Cut as per dwg D4021
Prog Rev: **B**
Dwg Rev: **B**
Deburr as required

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 40 9-89
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110

QC
Quality Control

Memo
0.36

Work Order ID 166089

Monday, September 11, 2017 9:18:52 AM

166089

Page 2

Item ID: D4021-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle Plate
Start Date: 9/11/2017 Start Qty: 36.00 ***36*** Cust Item ID:
Required Date: 9/12/2017 Req'd Qty: 36.00 ***36*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.72				36	Ø	SEP 14 2017	DAS 9 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION: WA004	0.00 0.36				36	Ø	SEP 14 2017	DAS 19 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 3.60						17/9/19	SEP 13 2017

Picklist Print

Monday, September 11, 2017 9:18:57 AM

Page 1

Work Order ID: 166089

166089

Parent Item: D4021-1

D4021-1

Parent Item Name: Handle Plate

Start Date: 9/11/2017

Required Date: 9/12/2017

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

79.1800

0.1225

4.642105

M304S11GA

**

17/09/13

DAS
40
9-89

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

79.18

M137110

0.82

M137599

14.36

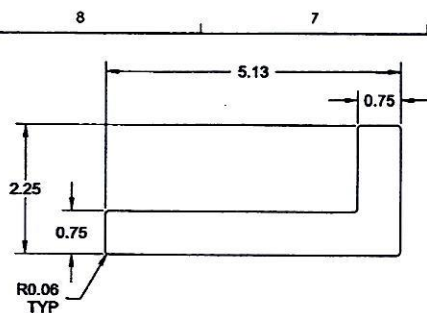
M138109

32

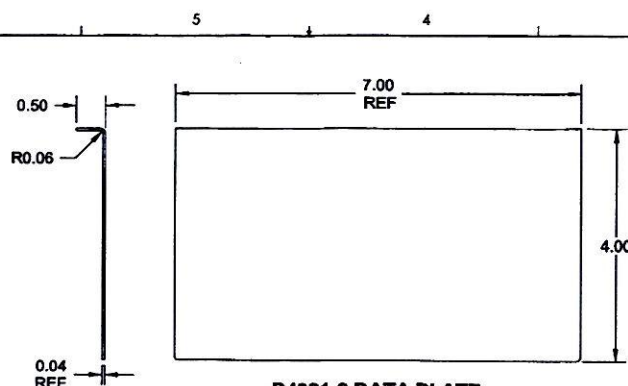
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32

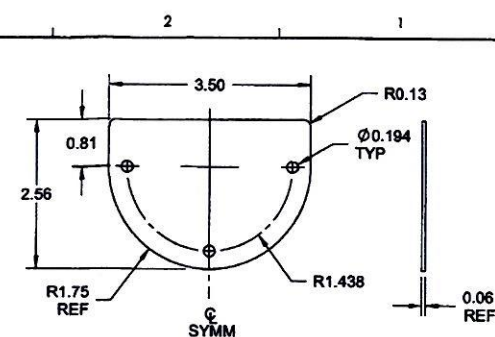
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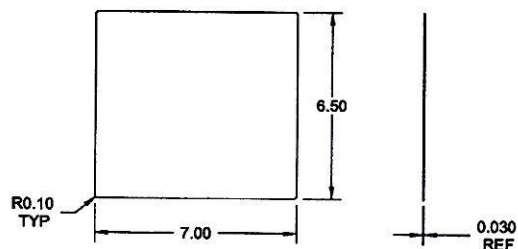
D4021-1 HANDLE PLATE



D4021-3 DATA PLATE
MAKE FROM D4021-3F

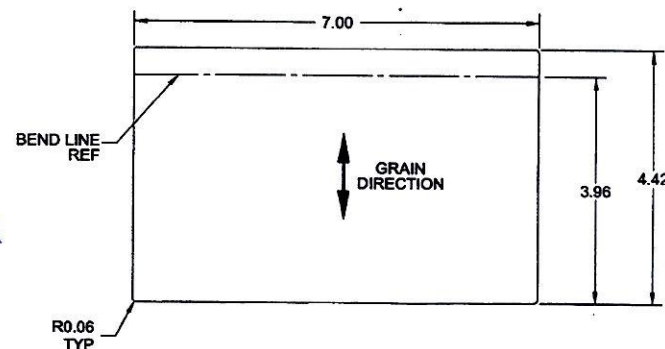


D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166089 MWS
1709-11



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
2010-04-16
NM

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
- 5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs
-3: 0.35 lbs
-5: 0.14 lbs
-11: 0.39 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4021	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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